

Date: Monday, 10/16/2006 2:01:20 PM  
 User: Kim Johnston

## Process Sheet

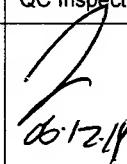
Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: PLUG		
Job Number	: 29005		Part Number	: D26511		
Estimate Number	: 10512		Drawing Number	: D2651 REV. B		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 10/16/2006 S.O. No. : N/A		Drawing Revision	: B		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 11/15/2006 Qty: 300 Um: Each		
Previous Run	: 28691					
Written By	: <u>JK</u>					
Checked & Approved By	: <u>JK 06/10/16</u>					
Comment	: Est: A 02.04.15 New Issue NG					
	: Est: B 05.12.12 added deburr EC					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6R0500	6061-T6 Round Bar .500"
Comment: Qty.: 0.0421 f(s)/Unit Total : 12.6315 f(s) <u>13.0 f</u> Material: 6061-T6 (QQ-A-225/8) 0.500" Dia (M6061T6R0500) Batch: <u>M102447</u> <u>JK</u> <u>06/10/30</u>		
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
Comment: HAAS CNC VERTICAL MACHINING #1 Hardinge CNC Lathe Small 1- Turn as per Folio FA219 and Dwg D2651 <u>JK</u> <u>06/10/30</u> <u>300</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>JK</u> <u>06/10/30</u> <u>300</u>		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK <u>JK</u> <u>06/10/30</u> <u>300</u>		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr as per dwg D2651 <u>JK</u> <u>06/10/30</u> <u>300</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06/12/11	2	permanent chg				4	 06/12/11

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 06/12/11  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 10/16/2006 2:01:20 PM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 29005

Part Number: D26511

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



counted

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

Y/ 06/11/09 x 278 300

7.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3  
(Only larger section necessary)

Y/ 06/12/09 x 300

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

Q.M

06/12/08

(X300)

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: FP

Q.M

06/12/08

(300)

10.0 QC21

FINAL INSPECTION/W/O RELEASE



(300)

Comment: FINAL INSPECTION/W/O RELEASE

Q.M 06/12/11

Job Completion



Y 06.12.11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	29005
Description: Plug	Part Number:	D2651-1
Inspection Dwg: D2651	Rev: B	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	06/10/30	Date:	06/10/30	Date:	

Rev	Date	Change	Revised by	Approved
A	03.12.22	New Issue	KJ/RF	TT



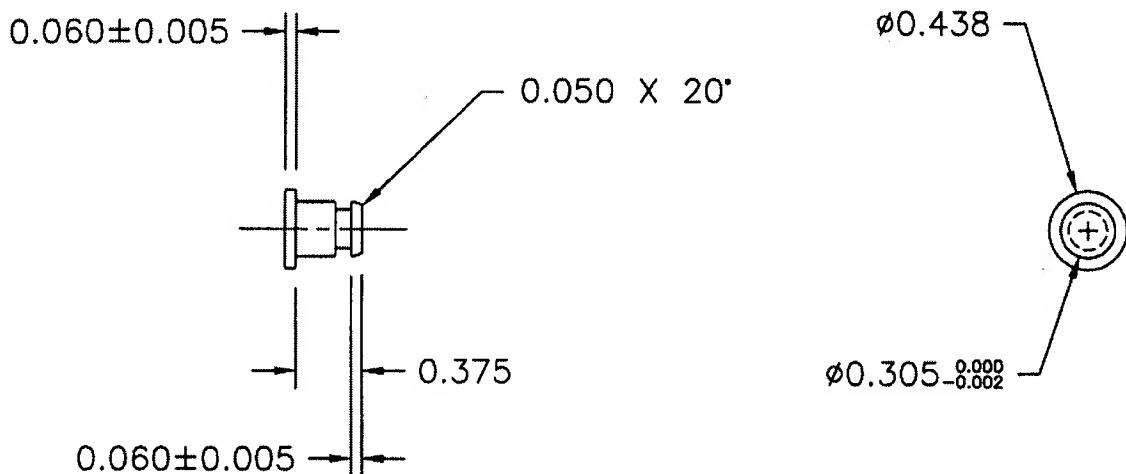
A circular stamp with the words "A COPY ISSUED" arranged in a circle, with a small "A" at the top.

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2651	REV. B	SHEET 1 OF 1
DATE 03.12.19		TITLE PLUG	SCALE 1:1	
A	97.03.25	NEW ISSUE		
B	03.12.19	ADD POWDER COAT, MS28775-008		

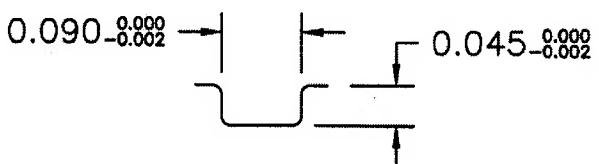
RELEASED

03.12.19 off

D2651-1 PLUG:



GROOVE DETAIL (SCALE 5:1)



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

D2651-1 PLUG

- 1) MATERIAL: 6061-T6 (QQ-A-225/8) OR 1100-0 (QQ-A-225/1)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 MAX

### D2651-3 O-RING

1) MATERIAL: BUNA N, 70 DUROMETER  
3/16 ID, 5/16 OD, 1/16 WIDTH  
(PARKER 2-008, MS28775-008 OR EQUIVALENT)